

5/13

DART AEROSPACE LTD	Work Order:	22521
Description: Stop	Part Number:	D2805-2
Dwg: D2805 rev. A	Qty:	40

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Issue W/O	JL	05/02/23	40
2	METAL	Cut blanks: 3.150" long -0.010" +0.030" Material: 6061-T6 (QQ-A-200/8) or (QQ-A-250/11) 1.5" x 1.5" bar Batch: M16954	JL	05/03/15	40
3	HAAS	Machine as per folio FA104	JL	05/03/16	40
4	QC	Inspect Level 2	JL	05/03/16	40
5	QC	Inspect Level 8	JL	05/03/16	40
6	METAL	Tumble & Deburr	JL	05/03/16	40
7	QC	Inspect Level 5	JL	05/03/16	40
8	FINISHING	Acid etch and Alodine per QSI 005	MJ	05/03/22	40
9	STORES	Identify and stock	SB	05/03/23	40
10	EXPEDITING	Close W/O Cost / part: \$5.80 SAE 05/03/23 6.66	JL	05/04/05	40

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	00.11.14	Revised Finishing step to Acid etch and Alodine	EC	

RELEASED

PC 05-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

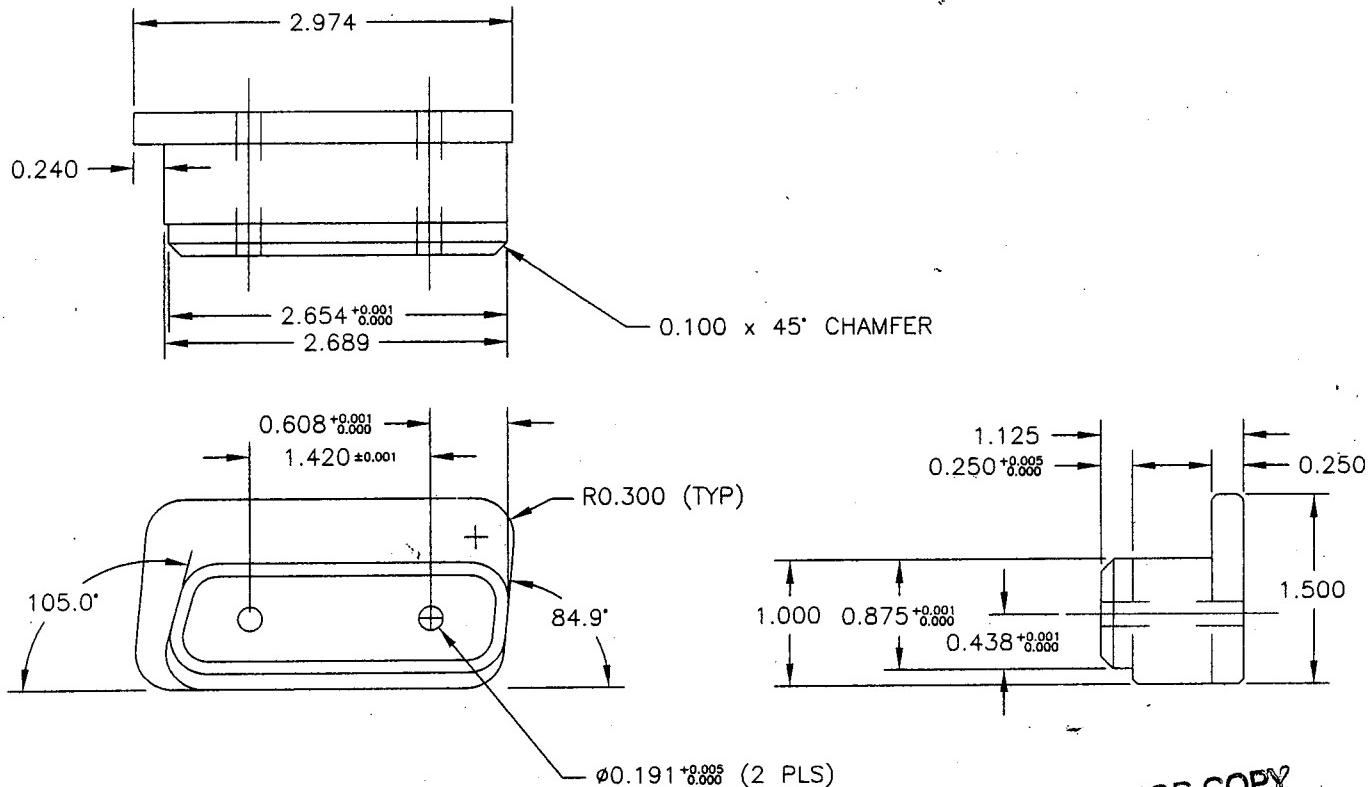
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



ISSUED
OR COPY

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2805	SHEET 1 OF 2
DATE		TITLE	SCALE
01.03.13		STOP	2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16



SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
DO NOT DISTRIBUTE

WORK ORDER
NO. 22521

D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
03:39 pm

Work Order No : 0022521
 Project Name : D2805-2
 Project For : WK513
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2805-2
 Description : Stop
 Manufactured : Yes
 Amount Req'd : 40
 Amount Done : 0
 Start Date : 02-22-05
 Est Finish Date : 03-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss)	0.00	0.00

DART AEROSPACE LTD

Work Order: 22521

Description: Stop

Part Number: A2805-2

Inspection Dwg: A2805 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	$\pm .010$	2.975	✓		H-G	
.240	$\pm .010$.240	✓		Vern	
.100 clunfer		.095	✓		Vern	
2.654	$\pm .001$ - 0					can't measure
2.689	$\pm .010$					"
.608	$\pm .001$ - 0					"
.191	$\pm .005$ - 0					"
.300						
1.420	$\pm .001$ - 0					
1.125	$\pm .010$	1.129	✓		Vern	
.250	$\pm .005$ - 0	.251	✓		d-m	
.250	$\pm .010$.255	✓		Vern	
1.500	$\pm .010$	1.501	✓		Vern	
1.000	$\pm .010$	1.001	✓		Vern	
.875	$\pm .001$ - 0	.8758	✓		mic	
.438	$\pm .001$ - 0		✓		microvern	

Measured by

J. L.

Audited by:

711

Prototype Approval:

N/A

1200

05/03/15

Date:

B-4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	